

Work Order ID 65929-2

Thursday, January 27, 2011 11:27:26 AM

Page 1

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 1/27/2011 Start Qty: 20.00

Required Date: 2/7/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

QC:

Date: 1/27/2011 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

B11-1-28

(3)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-1-28

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sulu12s

ccv12s
(132)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65929

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Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 1/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 11/02/01

(32)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

8 11/02/01

counted
(x32)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
1116787 Weld hardcoat as per Dwg D3437

EL 11-8-7 (x17)

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

8 11 02 10 00

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 11 02 10 00

(417)

180

Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:00

2:35

3105

17 BR 11-02-8.

W/O:		WORK ORDER CHANGES					
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Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

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Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

17 0 11/02/08

200



Packaging

Packaging

Identify as per dwg & Stock Location: FP17 0.00

Memo

0.00

17. 11-02-8.

210



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

11/02/09

MF 11-02-08.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 11:27:32 AM

Page 1

Work Order ID: 65929



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 1/27/2011

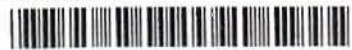
Required Date: 2/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.5000	0.149	3.136842			



304/316 Sheet .063



B11-1-28

Location

MAT

111323

116623

Loc Qty

254.5

0

254.5

Loc Code

116623

37

W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO

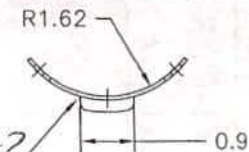
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

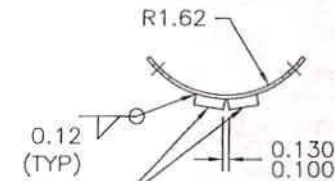
NO. 45929

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

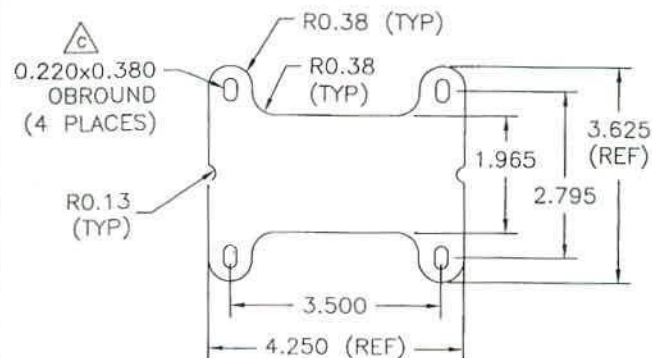
SECTION B-B



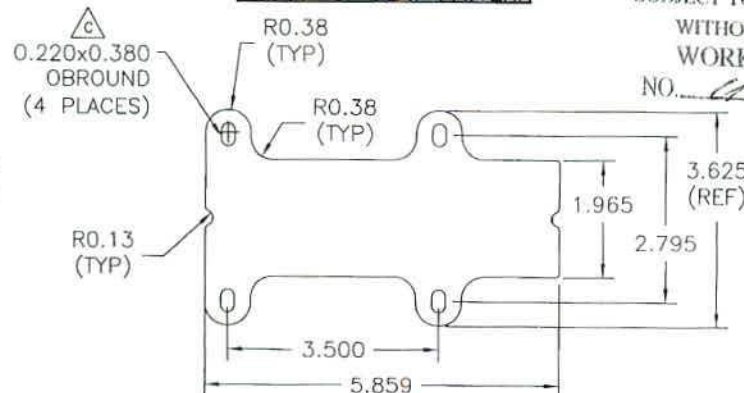
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-03 Ad
per ECU
952

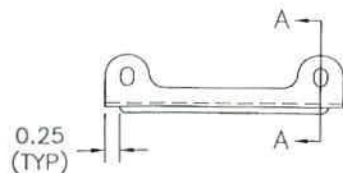
D3537-1F FLAT PATTERN



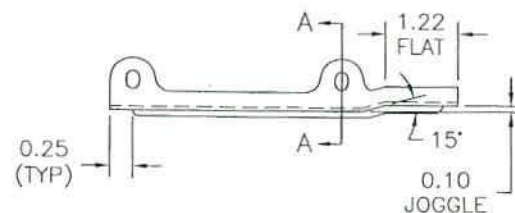
D3537-3F FLAT PATTERN



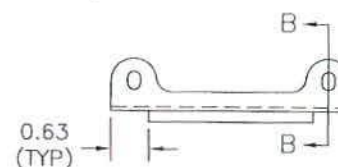
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



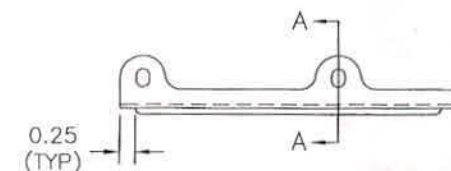
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A	APPROVED A
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

DART AEROSPACE USA, INC.
PORT HAZARD, MA

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